Work Orde		76		*96176*											
Revision ID:	D3198-1 Fitting			Accept	*N900	<u>040</u>	100	<b>)</b> * s	Setup Sta	IVI	S1* S2*				
Start Date: Required Date: Reference:	1/21/13 2/06/13	Start Qty: 10.0 Req'd Qty: 10.0			Cust Item Customer:	ID:									
Approvals:	Process Plan	n:	Date: /3-01-2 Date:	/		ate:		I	Run Sta Sto	17	R1* R2*				
Sequence ID/ Work Center II	)	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp				
Draw Nbr	Revi	sion Nbr							•						
D3198	Rev	A													
*100 *100* Waterjet FLOW CNC Waterje	et		s per Dwg D3198 Dwg Re f necessary	0.00 v: <b>/4</b> Prog Rev: <b>/</b>	<b>4</b> 2-			13	٠.		Jm13-3-1				
110		QC2-Inspect parts o	ff machine FAI/FAIB	0.00											
*110* QC Quality Control		Memo		0.00				13		··	Jm13-31				
120 * <b>12</b> 0*		QC8- Inspect parts -	second check	0.00 SM				10			•				
QC		Memo		0.00 133	식			14	-						

Quality Control

			DQA:	Date:	\$.
NCR:	Yes /	WORK ORDER NON-CONFORMANCE / UPDATE			

											QA Clos	ed:	Date:	
Work Orde	er:			•		DISPOSITION				AGAINST DI	PARTMI	NT/PRO	CESS	
Part f	- No					Rework Scrap Use-as-is			Skid-tube Machining noforming	Crosstube Small Fab Finishing	Rec/	Prod. Eng Store/Pa	ckaging	Engineering Quality Other
NCR I	No					Work Order Update			Large Fab	Composite	<u> </u>	S	Supplier	
Root					Descri	ption of work order update	- 1	nitial	Ac	ction	Sign	Ž.		
Cause		Date	Step	Qty	,	or Non-conformance	Ch	ief Eng	Desc	cription	Date	. Ve	rification	QC Inspector
Doc/Data									-					
Equip/Tooling											1			
Operator														
Material														
Setup														
Other		•			1				1					
Process												1		
Supplier									1					
Training														
Unapproved				<u> </u>										
		····				F.	AUL	T CATE	GORY					
Landi	ng G	ear				General					_		_	7
		Bending				Bend		Grain			Ovalized	i		Pressure/Forced
	Ц	Centre No	ot Concer	ntric to	o/s	BOM/Route		Hardwa	ıre		Over/U	nder toler:	ance	Temperature/Cure
		Cracks				_Broken/Damaged		Inspect	ion Incomplete		Part Inc	orrect	_	Weld
		Crushed/0	Crimped.			Burrs		Instruct	tions Incomplete/	/Unclear	Part Los	t/Missing		Wrong Stock Pulled
		Cuffs				Contamination		Mainte	enance		Part Mo	ved		
		Heat Trea	t			Countersink		Mislabe	eled		Position	ed Wrong	· –	→
		Inspection	n Strip in	Tube		Cut Too Short		Misrea	d ·	L	Power I	.oss/Surge	· _	Other
		Ripples in	Bend			Drill Holes		Offset			<del></del>			
		Torque W	aves in E	in Extrusion Drawing			Out of Calibration							
	Turning Sequence Finish				Out of	Sequence					LUMBA LANGE STATE OF THE STATE			
		Wave/Tw	ist in Tub	be Folio			Outside	e Dimensions						

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Orde		176		*961					Page	2		
Revision ID: Item Name:	D3198-1 Fitting			Accept	*N900	<u>040</u>	100	<b>)*</b> s	Setup Star Stop	ł /J	S1* S2*	
Start Date: Required Date: Reference:	1/21/13 2/06/13	Start Qty: 10.00 Req'd Qty: 10.00	*10* *10*		Cust Item : Customer:	ID:						
Approvals:		n:	-			ate:		F	Run Star Stoj	,	R1* R2*	
Sequence ID/ Work Center II 130 *130* Brake NC Brake NC	)	Operation Description  NC BRAKE  Memo I-Deburr if n	ecessary 2-Form as per D	Set Up/ Run Hours 0.00 0.00 0wg D3198	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp	SB 13/0
140 <b>*1 4 n *</b> QC Quality Control		QC5- Inspect part comple	teness to step on W/O	0.00 0.00 SMP 13.3	13			13			· ·	
150 * <b>15</b> 0*		Grey Sandtex(Ref.4.3.5.6	) per QS1005 4.3	0.00				LOV	S N	n - / 1	1/4-	2 /2

Powdercoat

Powder Coating

0.00

\_OVEN TEMPERATURE:

START TIME: 9-20
START TIME:

FINISH TIME:

3200

9750

m122066

										DQA	.: Date	e:	1
NCR:	Yes / 1	lo			WORK ORDER NON-	COI	<b>NFORM</b>	MANCE / UP	DATE		<del></del>		
										QA Closed	l: Dat	e:	
Work Orde	ar·		·		DISPOSITION				AGAINST DE	PARTMEN	T/PROCESS		
Work Orak			<u>,, , , , , , , , , , , , , , , , , , ,</u>		Rework	٦	Skid-tube Crosstube			1	Water Jet		Engineering
Part I	No.				Scrap	1		Machining	Small Fab	Pr	od. Eng. Coor.	$\exists$	Quality
					Use-as-is	1		noforming	Finishing	Rec/Ste	ore/Packaging		Other
NCR I	No				Work Order Update	]		Large Fab	Composite	]	Supplier		
	-	1	1			T .	'a' - 1	Λ.		Cian 0		Т	···
Root				1	ption of work order update		Initial		tion	Sign &	Vanifi aaki an		OC Imamaatan
Cause	Da	e Step	Qty	•	or Non-conformance	Cr	nief Eng	Desc	ription	Date	Verification	1	QC Inspector
Doc/Data	$\vdash$											Ì	
Equip/Tooling											,		
Operator			1								·		-
Material													
Setup	Ш		İ									Ì	
Other	Ш						į				•		
Process	Ц											İ	
Supplier	Ш												
Training													
Unapproved	<u> </u>		Ш	l						<u> </u>			
					· · · · · · · · · · · · · · · · · · ·	AUI	T CATE	GORY					
Landi	ng Gear				General	_	٦		<u></u>	<b>-</b>	r		
	Bend	-			Bend		Grain		_	Ovalized			ressure/Forced
	Cent	e Not Conc	entric to	o/s	BOM/Route		Hardwa	re		Over/Unde	er tolerance	_	emperature/Cure
	Cracl	s			Broken/Damaged	L	Inspecti	on Incomplete		Part Incorr	ect	—	Veld
	Crusl	ed/Crimpe	d.		Burrs		Instruct	ions Incomplete/	/Unclear	Part Lost/I	Missing	\v	Wrong Stock Pulled
	Cuffs				Contamination		Maintenance			Part Move	d		
	Heat	Treat		Countersink			Mislabeled		Positioned	Wrong			
	Inspe	ction Strip	in Tube		Cut Too Short		Misread Power Loss/Surge Oth				Other		

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

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Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

Folio

Work Order  January-23-13 12:3			Page 3									
Revision ID:	198-1		Accept	*N900	<b>040</b>	100	)*	Setup	Start Stop	*NS1* *NS2*		
Start Date: 1/2 Required Date: 2/0 Reference:	Start Qty: 10.00 Req'd Qty: 10.00	*10* *10*		Cust Item I Customer:	D:							
	rocess Plan:	Date:	Tooling: SPC (Y/N):		ate:				Start Stop	*N *N	R1* R2*	
Sequence ID/ Work Center ID  160 *160* QC Quality Control	Operation Description QC3- Inspect Part Finish Memo		Set Up/ Run Hours 0.00	Tool ID	Tool#	Plan Code	Accept Qty	Qty	ľ	Reject Number	Insp. Stamp	Ĵ
*170* Packaging Packaging	Identify as per dwg & Sto- <b>Memo</b>	ck Location	<b>16 A</b> 0.00 0.00				12 x	<b>(</b>			13-3-21	ĺ
*180 *180* QC Quality Control	QC21- Final Inspection -  Memo	Work Order Release	0.00					[2	3/3	12	2) Mr (3-3-	~ (
											(3-3-	1

NCR:	Yes	/	No

DQA: \_\_\_\_ Date: \_\_\_\_ \* .\_\_

NCR: Y	es / No				WORK ORDER NON-C	CONFOR	RMANCE / UF	PDATE					
									QA Closed:	Date:			
Work Orde	r:				DISPOSITION		AGAINST DEPARTMENT/PROCESS						
	· ·				Rework	1	Skid-tube	Crosstube	]	Water Jet	Engineering		
Part N	0.				Scrap	1	Machining	Small Fab	Pro	d. Eng. Coor.	Quality		
					Use-as-is	] The	moforming	Finishing	Rec/Sto	re/Packaging	Other		
NCR N	o				Work Order Update	]	Large Fab	Composite		Supplier			
Root				Descri	ption of work order update	Initial	A	ction	Sign &				
Cause	Date	Step	Qty	1	or Non-conformance	Chief En	g Des	cription	Date	Verification	QC Inspector		
Doc/Data													
Equip/Tooling													
Operator	_												
Material	_												
Setup -													
Other	_		į										
Process	_		'										
Supplier													
Training	_		ļ										
Unapproved		1	<u>l</u>			ALUTCAT	FCORY		<u> </u>				
. 1*						AULT CAT	EGURY						
Landin	g Gear				General Bend	Grain			Ovalized		Pressure/Forced		
}	Bending Centre N	at Cansa	ntrio to	\(\( \)	BOM/Route	Hard		<del> </del>	Over/Under	tolerance	Temperature/Cure		
}	Cracks	or conce	munc to	<sup>0/3</sup>	Broken/Damaged	$\vdash$	ction Incomplete	-	Part Incorre	<b>⊢</b>	Weld		
	Crushed/	Crimned		-	Burrs	<del></del>	ctions Incomplete	/Unclear	Part Lost/M	<del> </del>	Wrong Stock Pulled		
-	Cuffs	Crimped	•	-	Contamination	<b>—</b>	tenance	-/ Sticicut	Part Moved	-			
<u>}</u>	Heat Trea	at		<b> </b>	Countersink	Misla		-	Positioned \				
ļ.	Inspection		Tube		Cut Too Short	Misre		<u> </u>	Power Loss		Other		
·	Ripples in	•			Drill Holes	Offse		L_	/	~ L			
T I	Torque V		Extrusio	n	Drawing	<b></b>	f Calibration						
ţ	Turning				Finish	<del></del>	f Sequence				·		
Ţ	Wave/Tv	-			Folio	<b>  </b>	de Dimensions						

January-23-13 12:57:22 PM

Work Order ID:

96176

Parent Item:

D3198-1

Parent Item Name:

Fitting

**Start Date: 1/21/13** 

Required Date: 2/06/13

**Start Qty: 10.00** 

Required Qty: 10.00

Comments:

IPP: A03.11.11New IssueKJ/RF

IPP Rev:B Now on Waterjet 07-01-09 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
<b>M304S11GA</b> 304/316 0.125 Sheet		Purchased	No			100	sf	89.3000	0.105	1 <del>.1052</del> 63	- X - W -		<u> </u>
				<b>Location</b>		Loc Oty	<u>L</u>	oc Code					
				MAT020		89.3							
				122	521	89.3			153	32 <u>9</u> 1			

NCR: Y	′es	/ No				WORK ORDER NON-	CON	NFORM	AANCE / UPD	ATE	•		
											QA Closed:	Date:	
Work Orde	er:	<u>.</u>				DISPOSITION	-			AGAINST DE	PARTMENT/		
Part N	lo					Rework Scrap Use-as-is		ı	Skid-tube Machining noforming	Crosstube Small Fab Finishing	-1	Water Jet d. Eng. Coor. e/Packaging	Engineering Quality Other
NCR N	10.				<del></del>	Work Order Update			Large Fab	Composite	]	Supplier	
Root				,	Descri	ption of work order update	П	nitial	Acti	on	Sign &		
Cause		Date	Step	Qty		or Non-conformance	Ch	ief Eng	Descri	ption	Date	Verification	QC Inspector
oc/Data													
quip/Tooling													
perator						,							
1aterial													
etup													
ther													
rocess													
upplier		ļ											
raining													
napproved		ļ											
						F	AUL	T CATE	GORY				
Landi	ng G	iear		•		General							_
		Bending				Bend		Grain			Ovalized		Pressure/Forced
		Centre No	t Concer	ntric to	o/s	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure
		Cracks				Broken/Damaged	Г	Inspect	on Incomplete		Part Incorred	ct	Weld
		Crushed/C	Crimped.			Burrs		Instruct	ions Incomplete/U	Inclear	Part Lost/Mi	ssing	Wrong Stock Pulled
		Cuffs				Contamination		Mainte	enance		Part Moved	<del></del>	
		Heat Trea	t			Countersink		Mislabe	eled		Positioned V	Vrong	ļ
		Inspection	n Strip in	Tube		Cut Too Short		Misread	d		Power Loss/	Surge	Other
		Ripples in				Drill Holes		Offset		_		<b>L</b>	
		Torque W		xtrusio	n	Drawing		Out of	Calibration				
		Turning Se			<u> </u>	Finish		Out of	Sequence				
		Wave/Twi	-			Folio	Outside Dimensions						

DQA:

Date:

DART AEROSPACE LTD	Work Order:	94174
Description: Fitting	Part Number:	D3198-1
Inspection Dwg: D3198 Rev: A		Page 1 of 1

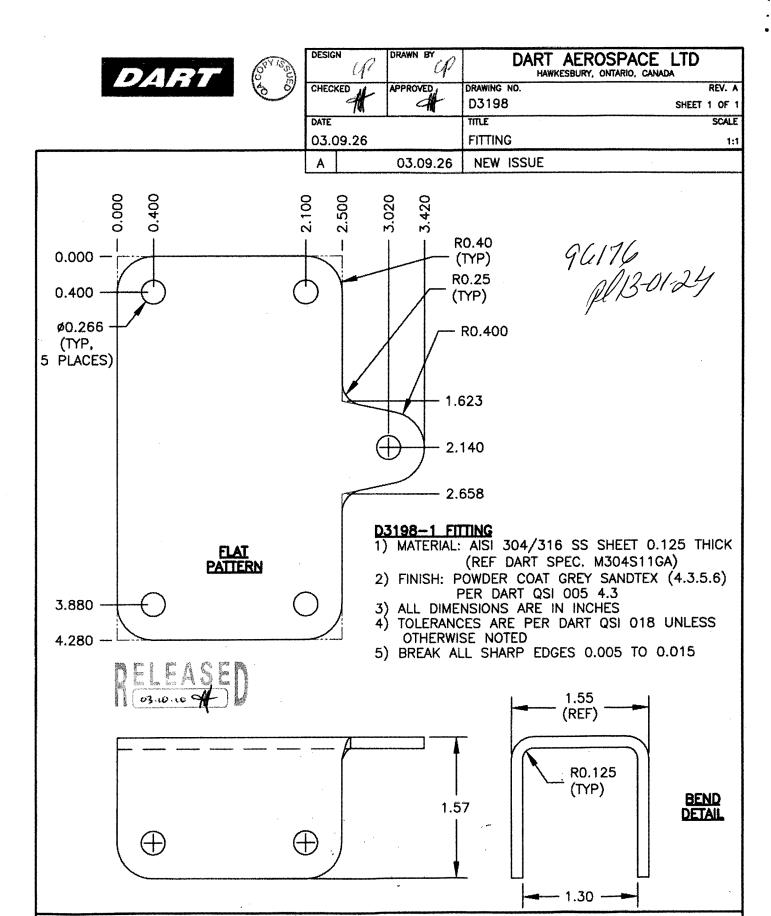
## FIRST ARTICLE INSPECTION CHECKLIST

X First Article	Prototype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.266	+0.006/-0.001	٥.۵५५	_		J	Jkmoi
4.280	+/-0.010	4.290	~		7	
2.500	+/-0.010	2.509'	_		7	
3.420	+/-0.010	3.419"	-		V	
0.400	+/-0.010	0.404"	~		V	
0.400	+/-0.010	0.404"			ν	
3.880	+/-0.010	3.882	_		V	
2.100	+/-0.010	2.103"	L.		ν	
3.020	+/-0.010	3.017"	-		V	
			-			
					-	
			<u> </u>			
						***
	****				<u> </u>	

Measured by:	Jm	Audited by: 5in		Prototype Approval:	N/A
Date:	13-3-12	Date: /3 ゞ /	)	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	07.03.13	New Issue	KJ/JLM ,	
В	08.05.28	Ø0.266 was Ø0.270	KJ/DD OK	



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